

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022641**Date Inspected:** 25-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

BAY#14

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 14 Anchor plate bearing block and 13CE Bottom panel stiffener. The weld designation reviewed is as follows:

APBBI-082-16

SEG3011C-079

Ultrasonic Testing:-

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG Segment 14 Anchor plate bearing block. The weld designation reviewed is as follows:

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APBBI-082-16

In process Inspection:-

BAY#14

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13CE Side Panel Stiffener. The weld joint was designated as: SEG3011L-203. The welder is identified as #066733. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13AE. The weld joint was designated as: SEG3007V-291/292. The welder is identified as #066163. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2233-ESAB.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 13CE Deck panel to Vertical Plate. The weld joint was designated as: SEG3011U-007. The welders are identified as #068097 and #067656. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-P-2214-TC-U4B-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 13BE Floor Beam to Corner Assembly. The weld joint was designated as: SEG3009B-141,142. The welder is identified as #051359. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint No: SEG3011K-001 located on OBG Segment 13CE Deck Panel Diaphragm. Welder is identified as #037933. ZPMC QC is identified as Mr. Wang Xu. Welding was performed with the weld repair report BWR-20476. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-FCM-Repair-1.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 14E Vertical Shear Plate to Top Anchorage Plate. The weld joint was designated as: SEG3019BB-001. The welder is identified as #058087. ZPMC CWI is identified as Mr. Geng Wei. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1. Please see the attached picture.

This QA Inspector observed the following work in progress:

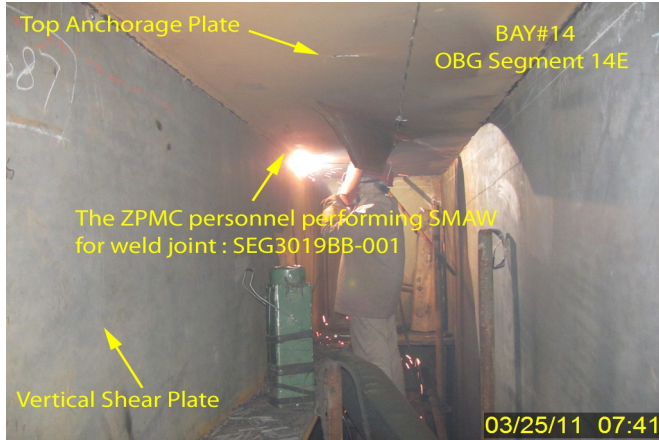
SMAW in the 4G position for the OBG Segment 14E Vertical Shear Plate to Top Anchorage Plate. The weld joint was designated as: SEG3019BB-023. The welder is identified as #201087. ZPMC CWI is identified as Mr. Geng

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Wei. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer